

Work Order ID 69817



Page 1

Thursday, May 19, 2011 2:31:54 PM

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/19/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 1105-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3537	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

110-5-76

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

64

110



QC2- Inspect parts off machine FAI/FAIB

0.00

110-5-76

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

5/19/12 7

QC

Memo

0.00

Quality Control

 COUNT
 +60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-
Identify as D3537-1

603

SP 11/05/10

140



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch □ A/R 2059B Hardcoat
M 117659 □ 1-Weld as per Dwg D3537 using Jig DT 8210 □ 2-Remove any
weld that penetrated through Wearpad if necessary

12 11-6-7 X60

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

S. W. 6/6/08

cont
460

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

5 molebe

counts
+100

170



Powdercoat

Powder Coating

M115128

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

9:15

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:45

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

60x 1/11/08

60x Bl 1-6-8

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Identify as per dwg & Stock Location:

FP-17.

0.00

60 of 60 11-6-08.

Packaging

Packaging

Memo

0.00

200



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/6/08
CMF

11-06-08

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, May 19, 2011 2:31:59 PM

Work Order ID: 69817



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 5/19/2011

Required Date: 5/25/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	192.8000	0.106	6.694737	6.7	MB11-5-26	

304/316 Sheet .063

Location	Loc Oty	Loc Code
MAT020	192.8	
117275	32.8	
117653	160	117653

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69817
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 11-5-08	Date: 11/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	2021

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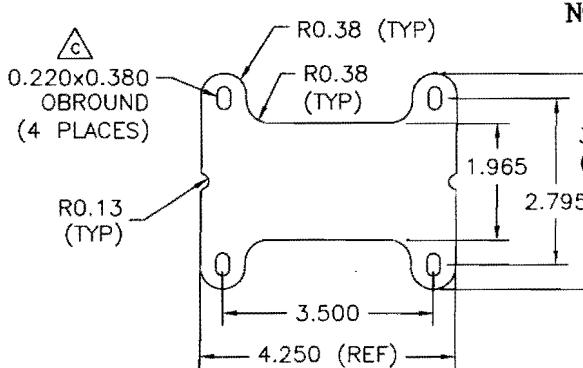
SHOP COPY

RETURN TO
ENGINEERING

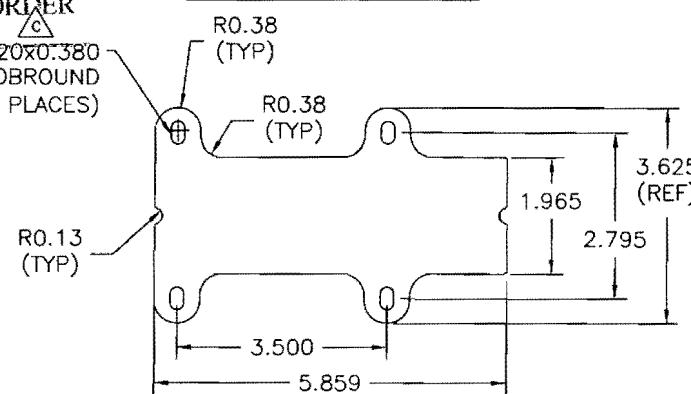
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

69817 04-05-19

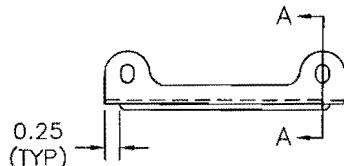
D3537-1F FLAT PATTERN



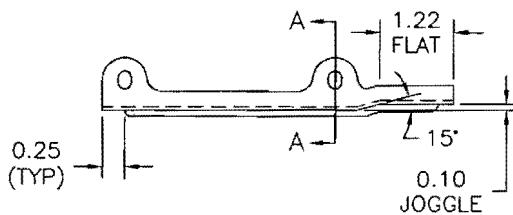
D3537-3F FLAT PATTERN



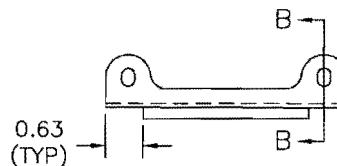
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART Aerospace USA, Inc. PORT HANCOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C SHEET 1 OF 1
07.04.13		SCALE 1:2
		WEARPAD

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